

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022201**Date Inspected:** 27-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of FCAW welding on bike path assembly BK004A8-062. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK004A8-062-023, 024, 035, 036

WPS-B-T-2132-ESAB

Welder-219414

2F/ FCAW

Weld- BK004A6-062-023, 024, 035, 160

WPS-B-T-2132-ESAB

Welder-054459

2F/ FCAW

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Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of FCAW welding on traveler rail assembly. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-037-009

WPS-B-T-2232-ESAB

Welder-217185

2G/CJP/FCAW

Weld- 20TR2-037-013, 015

WPS-B-T-2232-ESAB

Welder-053609

2G/CJP/FCAW

Weld- 20TR2-037-017

WPS-B-T-2232-ESAB

Welder-204342

2G/CJP/FCAW

Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening. ZPMC QC inspector Yu Zhi Lai was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 8 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK15A-001-030

WPS-B-P-2112-TC-U5b

Welder-057220

2G//SMAW/CJP

Weld-BK16B-001-017 ~ 022

WPS-B-T-2132-ESAB

Welder-054069

2F//FCAW/CJP

Weld-BK016A-001-012

WPS-B-P-2112-TC-U5b

Welder-040582

2G//SMAW/CJP

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Heat Straightening

HSR1 (B) 9965

BK008A1-001

Heat Straightening

HSR1 (B) 10109

BKX41- 001, 002

20TR2-030-001

WPS-B-P-2112-TC-U5b

Welder-057258, 052930, 052493, 500363, 044511

2G//SMAW/CJP

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on Lift 12. ZPMC CWI Li Yang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CB17

Weld-SP3031-017-054

WPS-B-P-2114-FCM-1

Welder-068764

4F/SMAW

CB17

Weld-FB4050-017-018

WPS-B-P-2114-FCM-1

Welder-040378

4F/SMAW

12AE

Weld-SEG3001AG-221

WPS-B-P-2114-TC-U4b-FCM-1

Welder-044504

4F/SMAW

CB17

Heat Straightening

HSR1 (B) 10127

CB3001-017-001/002

DP3037, DP3036, DP3035, DP3034

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
